

Work Order ID 136791-1

136791

Page 1

Tuesday, September 08, 2015 2:25:40 PM

Item ID: D350-615-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: GHW Modification, Fits LH or RH

Stop *NS2*

Start Date: 9/8/2015 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 9/8/2015 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals: Process Plan: MLS Date: SEP 08 2015

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-615-041	B

100 Document Control

Pick kit

DAS
6
9-89

SEP 09 2015

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
as per PPP D350-615-041 CHG003

MW 15-09-17

10

110

110

Small Fab

Small Fab

0.00

Memo

0.02

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***

DAS
30
9-89

8

SEP 17 2015

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
38
9-89

8

SEP 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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10

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.01							Stop 15/9/17
Quality Control									
140		0.00							
140									
Packaging	Memo	0.00							Stop 15/9/17
Packaging	Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.02							Stop 15/9/17
Quality Control									

SEP 14 2015

MS.9-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Tuesday, September 08, 2015 2:25:44 PM

Page 1

Work Order ID: 136791

136791

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015

Required Date: 9/8/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2282-041

Manufactured No

110

Each

1.0000

1

10

D2282-041

T Assembly

**

15/09/17 *[Signature]*

Location

Loc Qty

Loc Code

GA

1

B 12708 9

130708

1

1

D2282-043

Manufactured No

110

Each

10.0000

1

10

D2282-043

Saddle Assembly

**

15/09/17 *[Signature]*

Location

Loc Qty

Loc Code

GA

10

110681

6

110847

4

6

4

5/16-18-015C

Purchased No

110

Each

33.0000

3

30

5/16-18-015C

SS Bolt 5/16-181.5"K

**

DAS
8
9-89 SEP 09 2015

Location

Loc Qty

Loc Code

st572

33

m131962

33

30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Page 2

Work Order ID: 136791

136791

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015

Required Date: 9/8/2015

Start Qty: 10.00

Required Qty: 10.00

D3015-3

Manufactured No

110

Each

75.0000

3

30

D3015-3

Locknut

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

18

95758

8

96151

10

ST015

57

129764

4

132485

53

30

5/16WC

Purchased

No

110

Each

120.0000

12

120

5/16WC

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

st572

120

m131961

120

119

7/16-14-050C

Purchased

No

110

Each

10.0000

1

10

7/16-14-050C

SS Bolt 7/16 5"K Long (92198A672)

DAS
6
9-89

Location

Loc Qty

Loc Code

ST571

8

m131934

8

st572

2

120146

2

8

D3015-5

Manufactured

No

110

Each

42.0000

1

10

D3015-5

SS Nylock Nut 7/16

DAS
6
9-89

Location

Loc Qty

Loc Code

ST015

42

99599

42

10

SEP 09 2015

Tuesday, September 08, 2015 2:25:44 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Page 3

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136791

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015

Required Date: 9/8/2015

Start Qty: 10.00

Required Qty: 10.00

7/16WC

Purchased

No

110

Each

106.0000

2

20

7/16WC

Washer, SS Flat 7/16

SEP 09 2015

Location

Loc Qty

Loc Code

st572

106

120508

106

DAS
8
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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